

Groove cutting saw blades





Groove cutting saw blades for wood, chipboards and non-ferrous metals with moderate feed speeds.

D	В	b	Z	£
100	1.5	1.0	12	104.17
100	2.0	1.3	12	95.31
100	2.5	1.5	12	93.01
100	3.0	2.0	12	93.01
100	3.5	2.5	12	98.41
100	4.0	3.0	12	100.62
100	4.5	3.5	12	104.17
100	5.0	4.0	12	107.17
100	6.0	4.0	12	125.60
100	10.0	7.0	12	244.15
[
125	1.5	1.0	16	104.17
125	2.0	1.3	16	95.31
125	2.5	1.5	16	93.01
125	3.0	2.0	16	93.01
125	3.5	2.5	16	98.41
125	4.0	3.0	16	100.62
125	4.5	3.5	16	104.17
125	5.0	4.0	16	107.17
125	6.0	4.0	16	125.60
125	6.5	4.0	16	136.64
125	12.0	8.0	16	328.59
140	3.0	2.0	18	97.53
150	1.5	1.0	18	109.47
150	2.0	1.3	18	99.68
150	2.5	1.5	18	97.59
150	3.0	2.0	18	97.59
150	3.5	2.5	18	103.60
150	4.0	3.0	18	105.92
150	4.5	3.5	18	109.47
150	5.0	4.0	18	114.34
150	6.0	4.0	18	132.06
150	8.0	6.0	18	186.41
150	10.0	7.0	18	255.04
150	12.0	8.0	18	399.82

D B b z 180 1.5 1.0 18 112.34 180 2.0 1.3 18 100.62 180 3.0 2.0 18 100.62 180 3.5 2.5 18 106.47 180 4.0 3.0 18 109.47 180 4.0 3.0 18 109.47 180 4.0 3.0 18 116.17 180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 8.0 6.0 18 116.17 200 1.5 1.0 18 106.47 200 2.0 1.3 18 106.47 200 2.0 1.3 18 104.47 200 3.0 2.0 18 123.4 200 4.0 <	_				
180 2.0 1.3 18 103.60 180 3.0 2.0 18 100.62 180 3.5 2.5 18 106.47 180 4.0 3.0 18 109.47 180 4.5 3.5 18 112.34 180 5.0 4.0 18 116.17 180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 106.47 200 1.5 1.0 18 116.17 200 2.5 1.5 18 103.60 200 2.5 1.5 18 103.60 200 3.0 2.0 18 116.17 200 3.0 2.0 18 116.17 200 4.0 3.0 18 123.4 200 4.0 3.0 18 124.4 200 1.0 8.0 <td>D</td> <td>В</td> <td>b</td> <td>Z</td> <td></td>	D	В	b	Z	
180 2.5 1.5 18 100.62 180 3.5 2.5 18 106.47 180 4.0 3.0 18 109.47 180 4.5 3.5 18 112.34 180 4.5 3.5 18 112.34 180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.5 1.5 18 103.60 200 2.5 1.5 18 103.60 200 3.0 2.0 18 132.34 200 3.0 2.0 18 132.34 200 4.0 3.0 18 123.4 200 10.0 8.0 18 182.33 200 10.0 8.0	180	1.5	1.0	18	112.34
180 3.0 2.0 18 100.62 180 3.5 2.5 18 106.47 180 4.0 3.0 18 109.47 180 4.5 3.5 18 112.34 180 5.0 4.0 18 116.17 180 6.5 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.5 1.5 18 103.60 200 3.0 2.0 1.8 103.60 200 3.0 2.0 1.8 116.17 200 3.0 2.0 1.8 103.60 200 3.0 2.0 1.8 103.60 200 4.0 3.0 18 123.4 200 1.0 8.0 1.8 140.47 200 1.0	180	2.0	1.3	18	103.60
180 3.5 2.5 18 106.47 180 4.0 3.0 18 109.47 180 4.5 3.5 18 112.34 180 5.0 4.0 18 116.17 180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 103.60 200 2.5 1.5 18 103.60 200 3.0 2.0 18 110.17 200 3.0 2.0 18 112.34 200 3.0 2.0 18 112.34 200 4.0 3.0 18 112.34 200 1.0 8.0 18 140.47 200 1.0 8.0 18 132.54 200 1.0 8.0<	180	2.5	1.5	18	100.62
180 4.0 3.0 18 109.47 180 4.5 3.5 18 112.34 180 5.0 4.0 18 116.17 180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.0 2.0 18 116.17 200 3.0 2.0 18 103.60 200 3.0 2.0 18 110.17 200 4.0 3.0 18 112.34 200 4.0 3.0 18 114.77 200 1.0 8.0 18 132.64 200 1.0 8.0<	180	3.0	2.0	18	100.62
180 4.5 3.5 18 112.34 180 5.0 4.0 18 116.17 180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.0 2.0 18 110.17 200 3.0 2.0 18 112.34 200 4.0 3.0 18 112.34 200 5.0 4.0 18 140.47 200 10.0 8.0 18 382.83 200 10.0 8.0 18 123.54 225 4.0 3.0 18 123.54 225 5.0 4.	180	3.5	2.5	18	106.47
180 5.0 4.0 18 116.17 180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 1.5 18 103.60 200 3.0 2.0 18 116.17 200 4.0 3.0 18 112.34 200 4.0 3.0 18 119.95 200 6.0 4.0 18 140.47 200 10.0 8.0 18 382.83 200 10.0 8.0 18 136.68 225 4.0 3.0 18 123.54 225 5.0 4.	180	4.0	3.0	18	109.47
180 6.0 4.0 18 136.10 180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 3.0 2.0 18 136.00 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.0 3.0 18 119.95 200 6.0 4.0 18 140.47 200 10.0 8.0 18 382.83 200 10.0 8.0 18 123.54 225 4.0 3.0 18 123.54 225 5.0 4.	180	4.5	3.5	18	112.34
180 6.5 4.0 18 147.85 180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.5 3.5 18 116.17 200 4.0 3.0 18 119.95 200 6.0 4.0 18 140.47 200 10.0 8.0 18 382.83 200 12.0 8.0 18 182.54 225 4.0 3.0 18 123.54 225 4.5 3.5 18 128.03 225 5.0 4.0 18 135.68 225 5.0 4.	180	5.0	4.0	18	116.17
180 8.0 6.0 18 217.34 180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.5 3.5 18 116.17 200 5.0 4.0 18 140.47 200 6.0 4.0 18 182.54 200 10.0 8.0 18 382.83 200 12.0 8.0 18 123.54 225 4.0 3.0 18 123.54 225 4.0 3.0 18 123.54 225 5.0 4.0 18 155.22 225 7.0 4.0 18 133.68 2250 5.0 4	180	6.0	4.0	18	136.10
180 10.0 8.0 18 285.47 200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.5 3.5 18 116.17 200 5.0 4.0 18 149.95 200 6.0 4.0 18 140.47 200 10.0 8.0 18 382.83 200 12.0 8.0 18 578.75 225 4.0 3.0 18 123.54 225 5.0 4.0 18 133.68 225 5.0 4.0 18 133.68 225 5.0 4.0 18 188.54 250 5.0 4.0 20 186.37 250 6.0 4.	180	6.5	4.0	18	147.85
200 1.5 1.0 18 116.17 200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.0 3.0 18 112.34 200 5.0 4.0 18 119.95 200 6.0 4.0 18 140.47 200 10.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 133.68 225 4.0 3.0 18 123.54 225 5.0 4.0 18 133.68 225 5.0 4.0 18 155.22 225 7.0 4.0 18 188.54 100 140 20 186.37 250 5.0 4.0 20 186	180	8.0	6.0	18	217.34
200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.5 3.5 18 116.17 200 5.0 4.0 18 119.95 200 6.0 4.0 18 382.83 200 10.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 123.54 225 4.5 3.5 18 128.03 225 5.0 4.0 18 138.54 250 5.0 <t< td=""><td>180</td><td>10.0</td><td>8.0</td><td>18</td><td>285.47</td></t<>	180	10.0	8.0	18	285.47
200 2.0 1.3 18 106.47 200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.5 3.5 18 116.17 200 5.0 4.0 18 119.95 200 6.0 4.0 18 382.83 200 10.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 382.83 200 12.0 8.0 18 123.54 225 4.5 3.5 18 128.03 225 5.0 4.0 18 138.54 250 5.0 <t< td=""><td></td><td></td><td></td><td></td><td></td></t<>					
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200 2.5 1.5 18 103.60 200 3.0 2.0 18 103.60 200 3.5 2.5 18 110.17 200 4.0 3.0 18 112.34 200 4.5 3.5 18 116.17 200 5.0 4.0 18 119.95 200 6.0 4.0 18 140.47 200 10.0 8.0 18 382.83 200 12.0 8.0 18 578.75 200 12.0 8.0 18 123.54 225 4.0 3.0 18 123.54 225 5.0 4.0 18 133.68 225 5.0 4.0 18 133.68 225 7.0 4.0 18 188.54 250 5.0 4.0 20 186.37 250 5.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 6.0 4.					
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225 4.5 3.5 18 128.03 225 5.0 4.0 18 133.68 225 6.0 4.0 18 155.22 225 7.0 4.0 18 155.22 225 7.0 4.0 18 188.54 250 4.5 3.5 20 183.35 250 5.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95					
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225 6.0 4.0 18 155.22 225 7.0 4.0 18 188.54 250 4.5 3.5 20 183.35 250 5.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95	225	4.5	3.5	18	128.03
225 7.0 4.0 18 188.54 250 4.5 3.5 20 183.35 250 5.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95	225	5.0	4.0	18	133.68
250 4.5 3.5 20 183.35 250 5.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95	225	6.0	4.0	18	155.22
250 5.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z f.	225	7.0	4.0	18	188.54
250 5.0 4.0 20 186.37 250 6.0 4.0 20 186.37 250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z f.					
250 6.0 4.0 20 186.37 250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £	250	4.5	3.5	20	183.35
250 8.0 6.0 20 227.74 280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £	250	5.0	4.0	20	186.37
280 4.0 3.0 22 188.99 280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £	250	6.0	4.0	20	186.37
280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £	250	8.0	6.0	20	227.74
280 6.0 4.0 22 203.40 300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £					
300 6.0 4.0 24 233.93 300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £	280	4.0	3.0	22	188.99
300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £	280	6.0	4.0	22	203.40
300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £					
300 8.0 6.0 24 422.34 300 10.0 8.0 24 482.95 D B b z £	300	6.0	4.0	24	233.93
300 10.0 8.0 24 482.95 D B b z £					
D B b z £					
100 4.0 2.8 6 27.35	D	В	b	z	£
	100	4.0	2.8	6	27.35

[rpm] Recommended speed of revolution 10000 9000 8000 7000 6000 5000 4000 150 200 250 300 350 400 450 500 55**(**mm] 3000



Biscuit

Jointers

Groove cutting saw blade for wood and boards. When grooving 0 across the grain, use half the speed compared to Page along the grain.

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